

5/43

DART AEROSPACE LTD	Work Order:	24547
Description: Washer	Part Number:	D3137-5
Dwg: D3137 Rev. D	Qty:	20 37
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JG	05.10.13	20
2	MC	Machine as per Folio FA471 and Dwg D3137 Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8) 0.750" Bar (M6061T6R0.750) Identify as D3137-5 Batch: <u>M17307</u>	JG	05/10/23	37
3	QC2	Inspect parts as they come off the CNC machine	JG	05/10/23	37
4	QC8	Second check	BL	05.10.23	37
5	MC	Deburr	JG	05/10/23	37
6	FP	Chemical Conversion Coat as per QSI 005 4.1	SAD	05/11/19	37
7	QC3	Inspect Chemical Conversion Coat	J	05.11.20	37
8	QC5	Inspect work to Step 7	J	05.11.20	37
9	ST	Identify and Stock LOC: 402	CL	05/11/20	37
10	AC	Cost / part _____	SAC	05-11-29	37
11	DC	Close W/O Inspect Level 21	D	05/11/29	37

Rev	Date	Change	Revised By	Approved
A	04.11.04	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature]
 04/11/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/11/22

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3137	REV. D SHEET 1 OF 4
DATE 04.11.03		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.17	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.	
C	03.08.15	ADD -043	
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS	

RELEASED
64.11.23 #

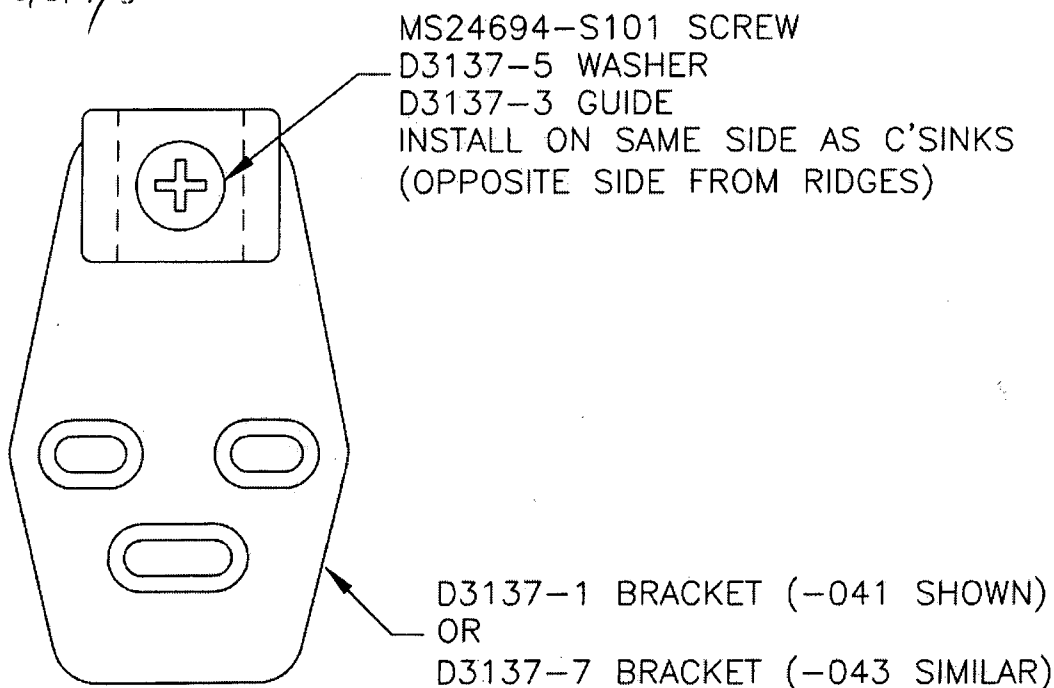
UNDER REVIEW

05.08.29 #

D3137-041 ONLY
D3137-1

CANCEL
FOR THIS

W/O. # 05.10.13



D3137-041 BRACKET ASSEMBLY (SHOWN)
D3137-043 BRACKET ASSEMBLY (SIMILAR)

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WITHOUT NOTICE

WORK ORDER

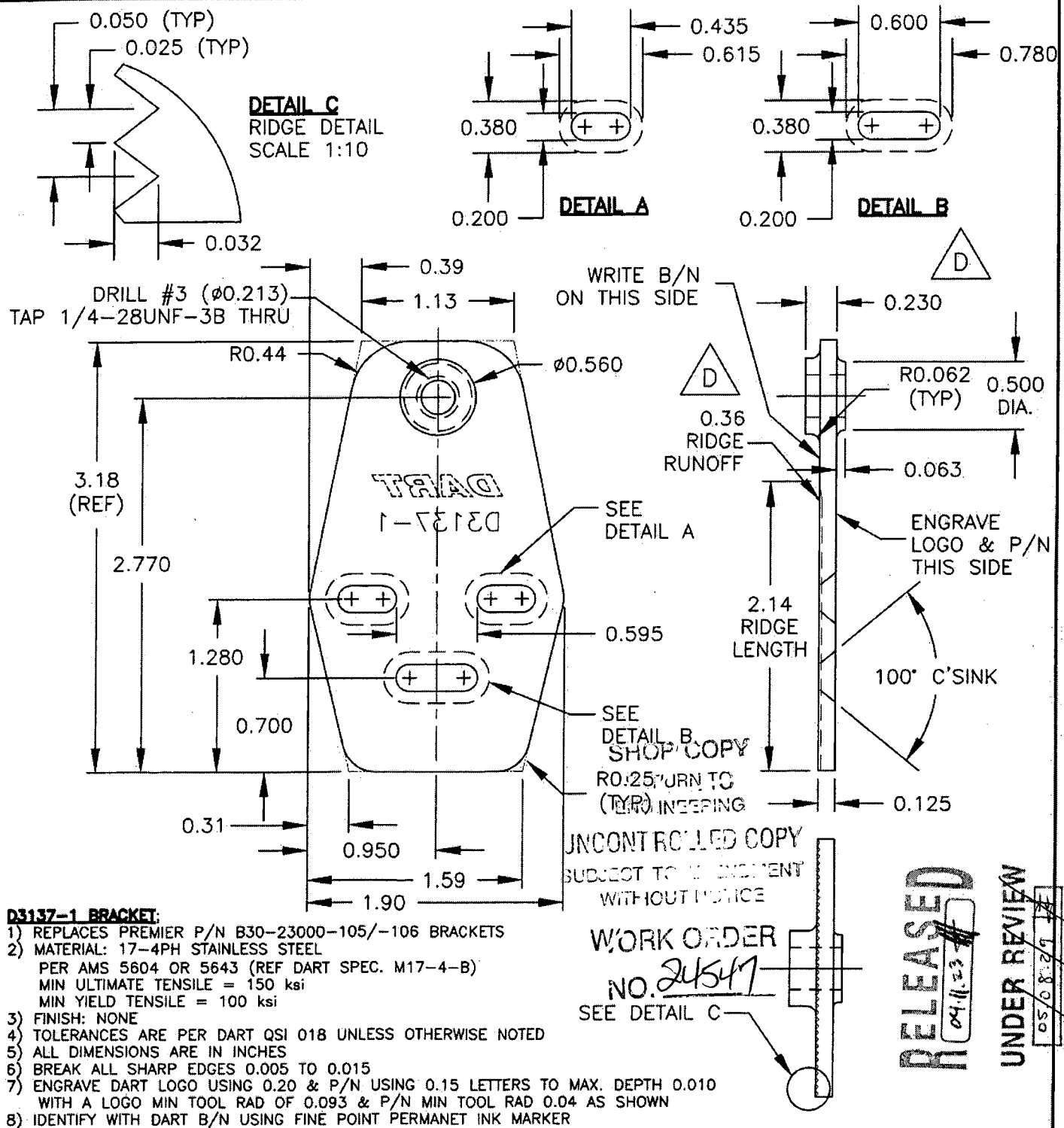
NO. 24547

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DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3137	REV. D SHEET 2 OF 4
DATE 04.11.03	TITLE BRACKET ASSEMBLY		SCALE 1:1



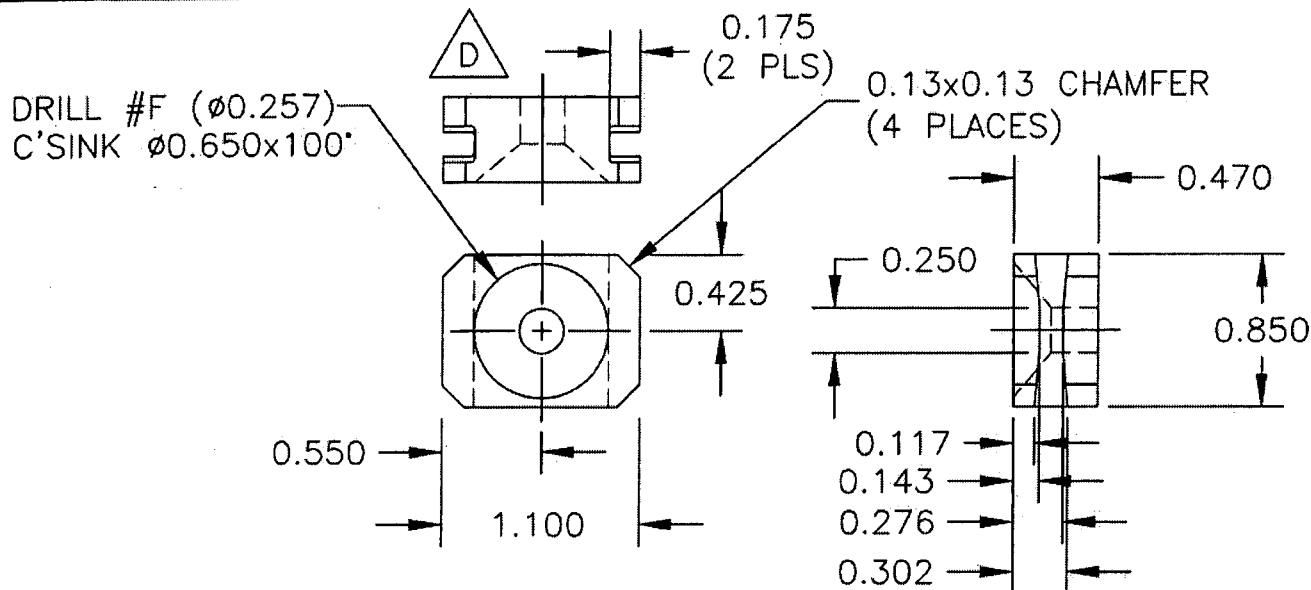
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RELEASED
04.11.03UNDER REVIEW
05.08.07ONLY CANCEL
D3137-0417
D3137-1



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3137	REV. D SHEET 3 OF 4
DATE 04.11.03		TITLE BRACKET ASSEMBLY	SCALE 1:1



D3137-3 GUIDE

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015

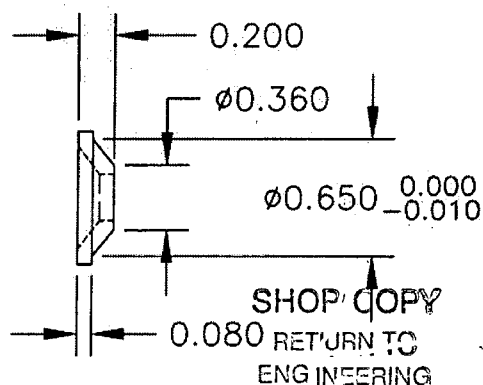
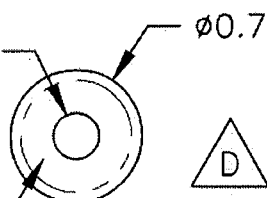
RELEASED
04.11.03

UNDER REVIEW

05.08.29
D3137-0412 ONLY
D3137-01

C'SINK $\phi 0.500 \times 100^\circ$
CANCEL REF 05.12.13

DRILL #F ($\phi 0.257$) $\phi 0.740$



D3137-5 WASHER

- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

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FOR FORCE

WORK ORDER

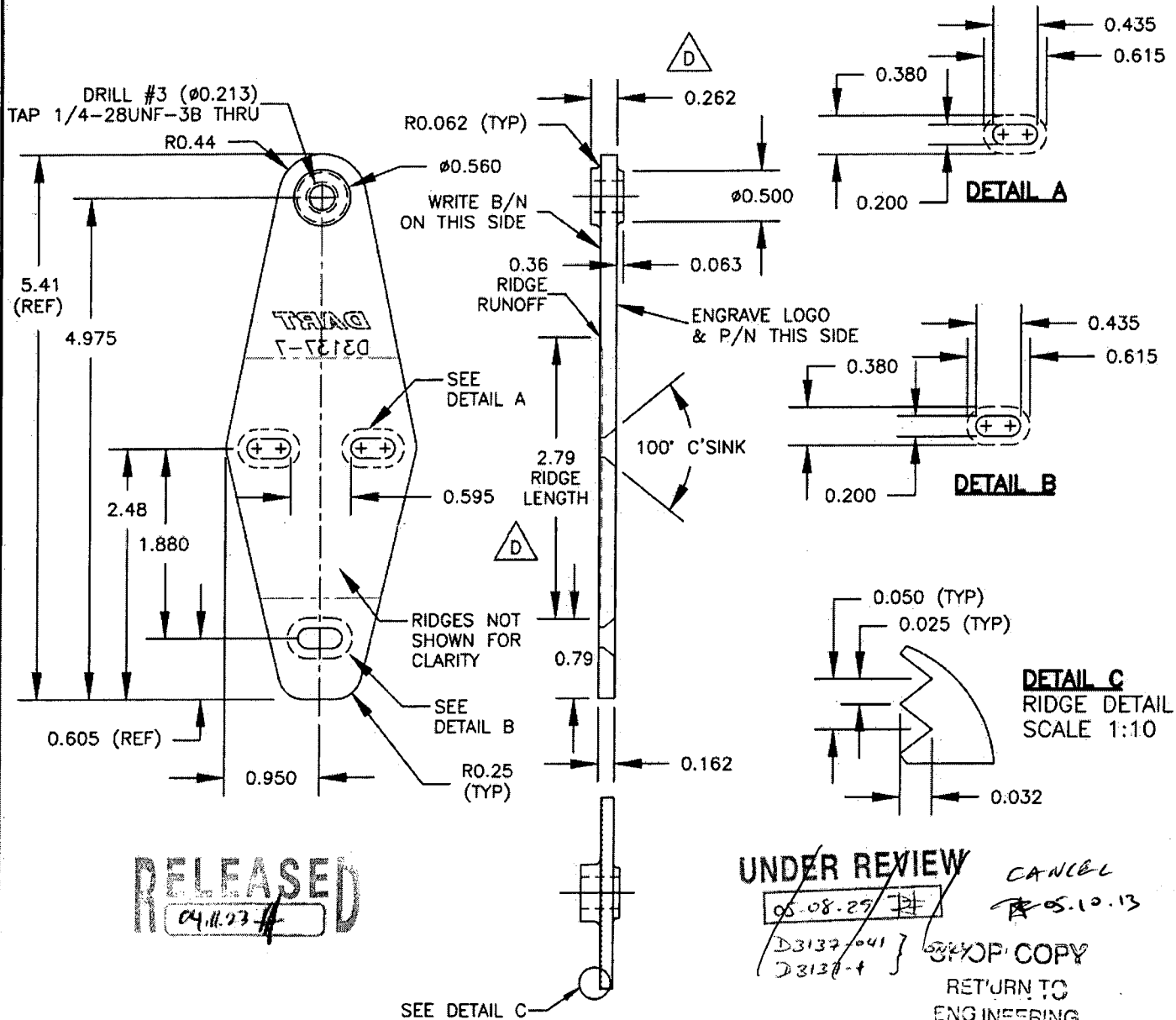
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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3137	REV. D SHEET 4 OF 4
DATE 04.11.03		TITLE BRACKET ASSEMBLY	SCALE 2:3

**UNDER REVIEW**

CANCEL

05.10.13

D3137-041
D3137-1

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FROM NOTICE

WORK ORDERNO. 24547**D3137-7 BRACKET:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 13, 2005
10:00 am

Work Order No : 0024547
Project Name : D3137-5
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D3137-5
Description : Washer
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 10-12-05
Est Finish Date : 10-25-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00